

Date: Tuesday, 01/05/2007 2:24:01 PM
User: Linda Lacelle

Process Sheet

Split 2005-16

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : GUIDE ASSEMBLY

Job Number : 31870-4

Estimate Number : 12709

P.O. Number : N/A

This Issue : 01/05/2007

S.O. No. : 14

Prsht Rev. : NC

First Issue : N/A

Type : LARGE FAB ASSY

Previous Run : 31870

Part Number : D3572041

Drawing Number : D3572 REV.B

Project Number : N/A

Drawing Revision : B

Material : 13/05/2007

Due Date

Qty: 60 Urm: Each

Written By

Checked & Approved By : Est Rev:A New Issue 07-02-07 JLM

Comment : est rev B revB dwg EC

Additional Product

Job Number:

Seq. #: Machine Or Operation:

Description :

1.0 D35723 GUIDE

Comment: Qty.: 4.0000 Each(s)/Unit Total: 240.0000 Each(s) (3)

GUIDE

Batch: B31912 = 117 B32172 =

PD 01-05-15 (14)

2.0 D35727 CAP

Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s)

CAP

Batch: B31914

PD 01-05-15 (14)

3.0 D35725 BRACKET

Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

BRACKET

Batch: B31913

PD 01-05-15 (14)

4.0 M6061T6T1000W188 6061T6 TUBE 1.00 X 188W

Comment: Qty.: 2.3405 f(s)/Unit Total: 140.4270 f(s)

6061-T6 Round Tube 1.00"x 0.188 wall

Batch: M18101 7.02

M18147

30.426

SUBSTITUTE 1" OD 6061-T6 Rod

LE 07.05.14

07/05/14

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1-Cut Tube D3572-1 as per Dwg D3572

B100080

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 31870

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Weld D3572-3 guides, D3572-7 caps and D3572-5 bracket as per Dwg D3572

A/R AL ROD

Batch:

M102756

3-Grind welds for end caps.

6.0

QC5

INSPECT WORK TO CURRENT STEP

0

Comment: INSPECT WORK TO CURRENT STEP

7.0

QC9

VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

12.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Completion



U 07/05/16
U 07/09/19 (6)

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-05-16	10.0	W/O was split for a Qty of 8 on this W/O. 5 remaining on B31870-2 W/O.	J	07-05-16	8	J 07-05-16	J 07-05-16	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-15	5.0	The distance between the D3572-3 Guides varies from 0.140" → 0.160.	LE 07-05-16 SEE ATTACHED EMAIL FROM DS	ACCEPTABLE	LE 07-05-16 SEE ATTACHED EMAIL FROM DS		LE 07-05-16	
07-05-15	5.0	1 x D3572-1 tube material was missing. No more left in stock.		Replace/substitute using, 1" OD 6061-T6 Solid Rod. → required EXTRA HEATING AND WELD MATERIAL				
07-05-15	5.0	1 part took. Used for testing, with solid bar.	J 07-05-15	test c. scrap, no replace.	LE 07-05-15	J 07-05-15	J 07-05-15	J 07-05-15

NOTE: Date & Initial entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3572	REV. A SHEET 1 OF 2
DATE 07.03.29	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV A	DATE 07.03.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]*

19.28

0.125

3.66

D3572-3 GUIDE
(4 PLACES)

3/16

4X

2X

D3572-1 TUBE

D3572-7 CAP

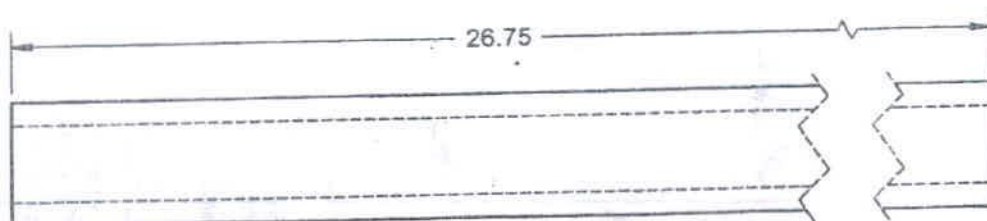
2X

D3572-041 GUIDE ASSEMBLY

D3572-5 BRACKET

D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE**

0.188 (REF)

Ø 1.000 (REF)

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

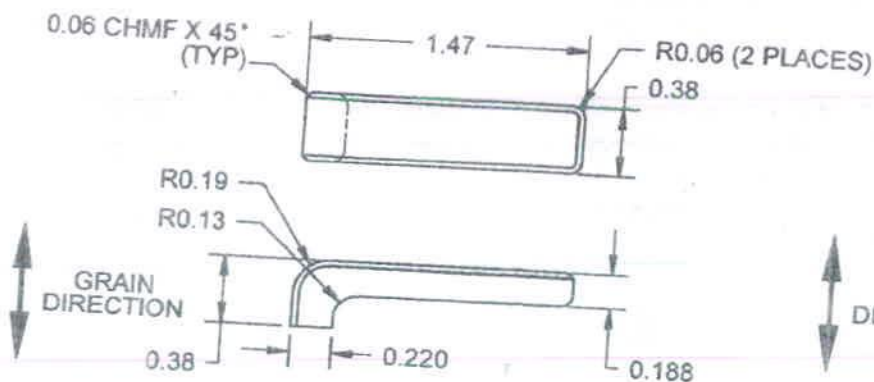
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WITHOUT NOTICE
WORK ORDER
NO. 31870)

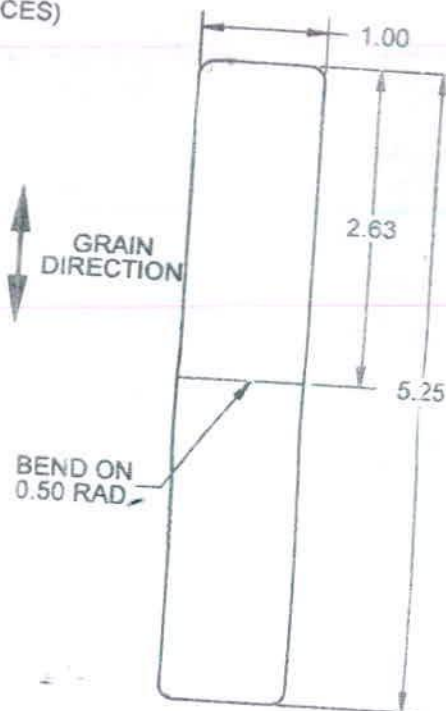
DART

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3572	REV. A
DATE 07.03.29		TITLE GUIDE ASSEMBLY	
		SHEET 2 OF 2	
		SCALE 2:3	

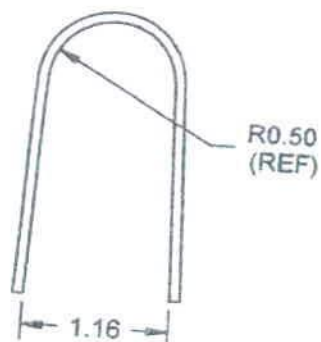
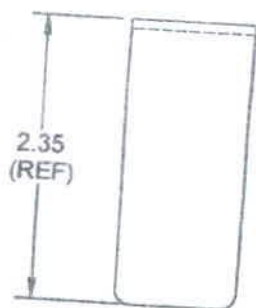


1 **D3572-3 GUIDE**

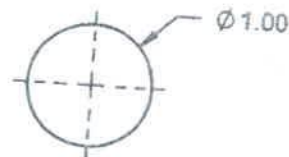
RELEASED

07.04.12 *#*

2 **D3572-5F FLAT PATTERN**



D3572-5 BRACKET
(MAKE FROM D3572-5F)



2 **D3572-7 CAP**

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WORK ORDER
31870

D3572-3/-5/-7 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/-7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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Leanne Elsliger

From: David Shepherd [dshepherd@dartaero.com]
Sent: September 12, 2007 3:36 PM
To: 'Leanne Elsliger'
Subject: RE: D3572-041 deviation

I think we should accept 0.156 and reject 0.178.

David

From: Leanne Elsliger [mailto:lelsiger@dartaero.com]
Sent: Wednesday, September 12, 2007 11:45 AM
To: 'David Shepherd'
Subject: D3572-041 deviation

David – there's a deviation on the D3572-041 guide assembly used in the D412-702-041A/B kits. The guide spacing is increased for 2 out of 6 welded assemblies. Instead of it being 0.125, it is 0.156 on one assembly, and 0.178 on another assembly. Is this acceptable? I've sent you a marked up fax.

Note that this is an old w/o with the drawing at rev. A...we are on rev C of the drawing now.

Thanks, Leanne

Leanne Elsliger, P.Eng
DART Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury, ON, K6A 1K7
T: (613) 632-5200
F: (613) 632-9311

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.485 / Virus Database: 269.13.15/1003 - Release Date: 9/12/2007 10:56 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/12	5.2	two (2) parts have the gap of 0.125" between D3572-3's at out of tol. one at 0.158 the other at 0.178.	07/09/12	→ one at 0.158 is acceptable as per email from David Shepherd → the other at 0.178 remove the D3572-3 and back clean	WS 07.09.14 07/09/12	En 07/09/12	WS 07.09.14	En 07/09/12
↓	↓	↓	07/09/12	Reposition with 0.125" Dim is good. Re weld as per QSI 004 33217-2	WS 07.09.13	En 07/09/13	WS 07.09.14	En 07/09/12
↓	↓	↓	07/09/12	* welding inspection *	WS 07/09/13	En 07/09/13	WS 07.09.14	En 07/09/12

NOTE: Date & initial all entries

